

Tuesday, March 10, 2015 1:48:38 PM

130426

Page 1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Adapter

Stop *NS2*

Start Date: 3/10/2015 **Start Qty:** 15.00

15

Cust Item ID:

Required Date: 3/10/2015 **Req'd Qty:** 15.00

15

Customer:

Reference:

Approvals: Process Plan: ML5 Date: 15-03-10

Tooling: _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3573	Rev A

100

0.00

100

BAND SAW

0.00

Bandsaw

Memo

Jeaspa Bandsaw

Cut blank 3.500" long

110

0.00

110

HAAS CNC VERTICAL MACHINING #1

0.00

HAAS 1

Memo

HAAS CNC vertical machine #1

Machine as per Folio FA677 and Dwg D3573

120

0.00

120

QC2- Inspect parts off machine FAI/FAIB

0.00

OC

Memo

Quality Control

Work Order ID 130426

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Page 2

Item ID: D3573-7 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Adapter
Start Date: 3/10/2015 Start Qty: 15.00 ***15*** Cust Item ID:
Required Date: 3/10/2015 Req'd Qty: 15.00 ***15*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00							
130						15	0		OK 2015-03-12
QC	Memo	0.00							
Quality Control									
140	Chemical Conversion Coat per QSI005 4.1	0.00							
140						15	0	15-3-13	J4
HandFinish	Memo	0.00							
Hand Finishing									
150	Grey Sandtex(Ref:4.3,5.6) per QSI005 4.3	0.00							
150						15	0	15-3-16	233
Powdercoat	Memo	0.00							
Powder Coating									
	START TIME: 11:20								
	FINISH TIME: 11:50								

Work Order ID 130426

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130426

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Item ID: D3573-7

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Adapter

Start Date: 3/10/2015 Start Qty: 15.00

15

Cust Item ID:

Required Date: 3/10/2015 Req'd Qty: 15.00

15

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							DAS 38 9-89
160						(15)			
QC	Memo	0.00							
Quality Control									MAR 17 2015
170	Identify as per dwg & Stock Location	0.00				15			
170									
Packaging	Memo	0.00							
Packaging									DAS 6 9-89
									MAR 18 2015
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									MW 15-03-18

DAS 38

Picklist Print

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Page 1

Work Order ID: 130426

130426

Parent Item: D3573-7

D3573-7

Parent Item Name: Adapter

Start Date: 3/10/2015

Required Date: 3/10/2015

Start Qty: 15.00

Required Qty: 15.00

Comments: IPP Rev:A New Issue 07-01-29 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.500X02.50 0		Purchased	No			100	f	15.0000	0.292	5			

M6061T6B0 500X02 500

6061-T6 Bar .500 x 2.50

Location

MAT001

M128247
M129972

Loc Qty

15

3

12

Loc Code

JP-15-03-11

3
1.5

DART AEROSPACE LTD		Work Order:	130426
Description: Adapter		Part Number:	D3573-7
Inspection Dwg: D3573 Rev: A		Page 1 of 1	

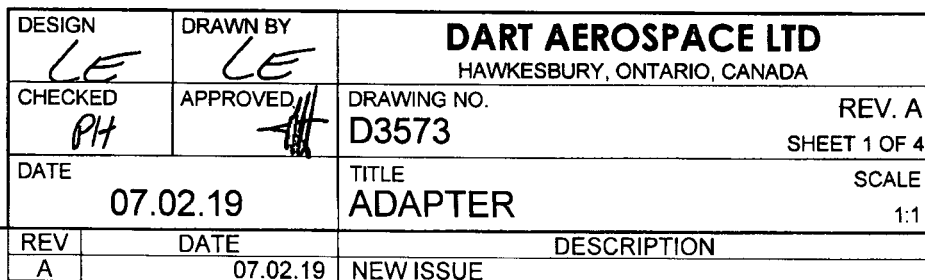
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

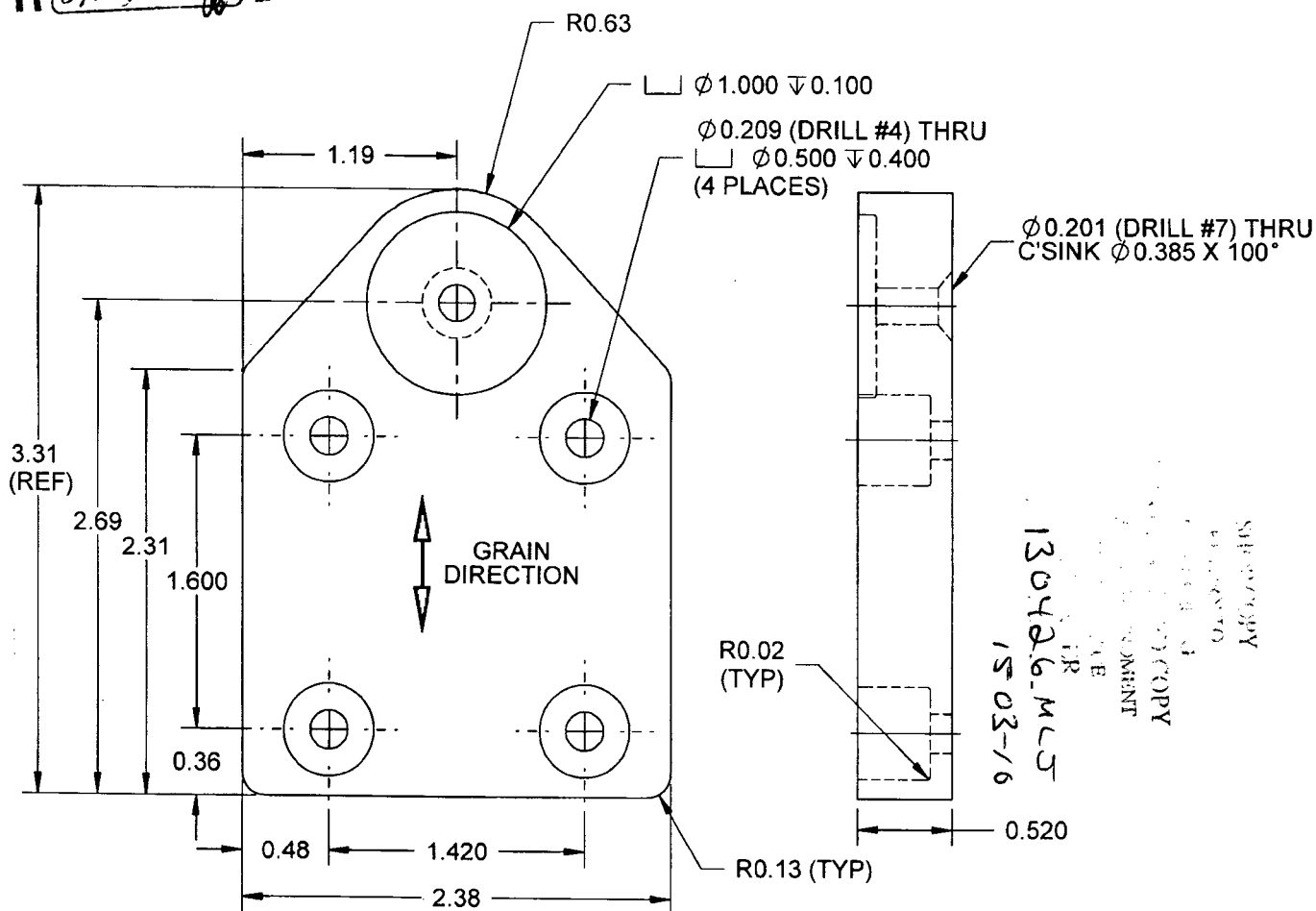
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.32	+/-0.030	3.312	✓		Vern	GA-13
2.75	+/-0.030	2.750	✓		"	"
0.36	+/-0.030	0.356	✓		"	"
1.600	+/-0.010	1.600	✓		"	"
0.48	+/-0.030	0.477	✓		"	"
2.38	+/-0.030	2.375	✓		"	"
1.420	+/-0.010	1.421	✓		"	"
1.813	+/-0.010	1.812	✓		"	"
Ø0.209	+0.005/-0.001	Ø0.210	✓		"	"
Ø0.201	+0.005/-0.001	Ø0.202	✓		"	"
Ø0.90 x 0.100	+/-0.010	Ø0.902 x .102	✓		"	"
Ø0.500 x 0.310	+/-0.010	Ø0.502 x .312	✓		"	"
0.390	+/-0.010	0.395	✓		Mic	GA-03
Ø0.385 x 100°	+/-0.010 x 0.5°	Ø0.390 x 100°	✓		Vern	GA-13
R0.63	+/-0.030	R0.625	✓		R-6	REF.
R0.13	+/-0.030	R0.125	✓		"	"
R0.02	+/-0.030	R0.015	✓		"	"

Measured by: Dn	DAS 08	Audited by: JFe	Prototype Approval:	N/A
Date: 15/03/12	9-89	Date: 2015-03-12	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	10.04.01	New Issue	KJ	

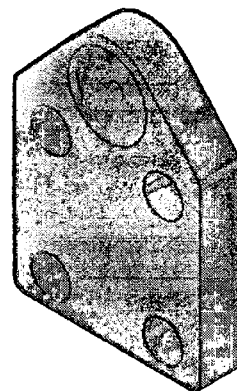


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07.03.22

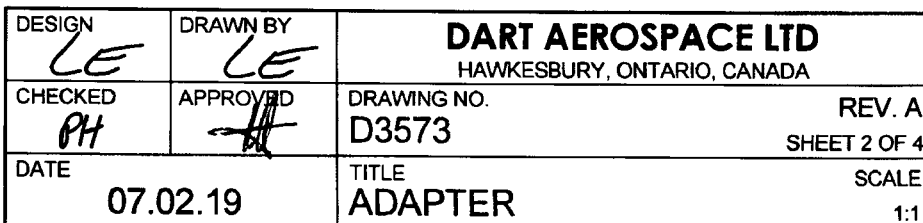


130426-ML5
1503-16

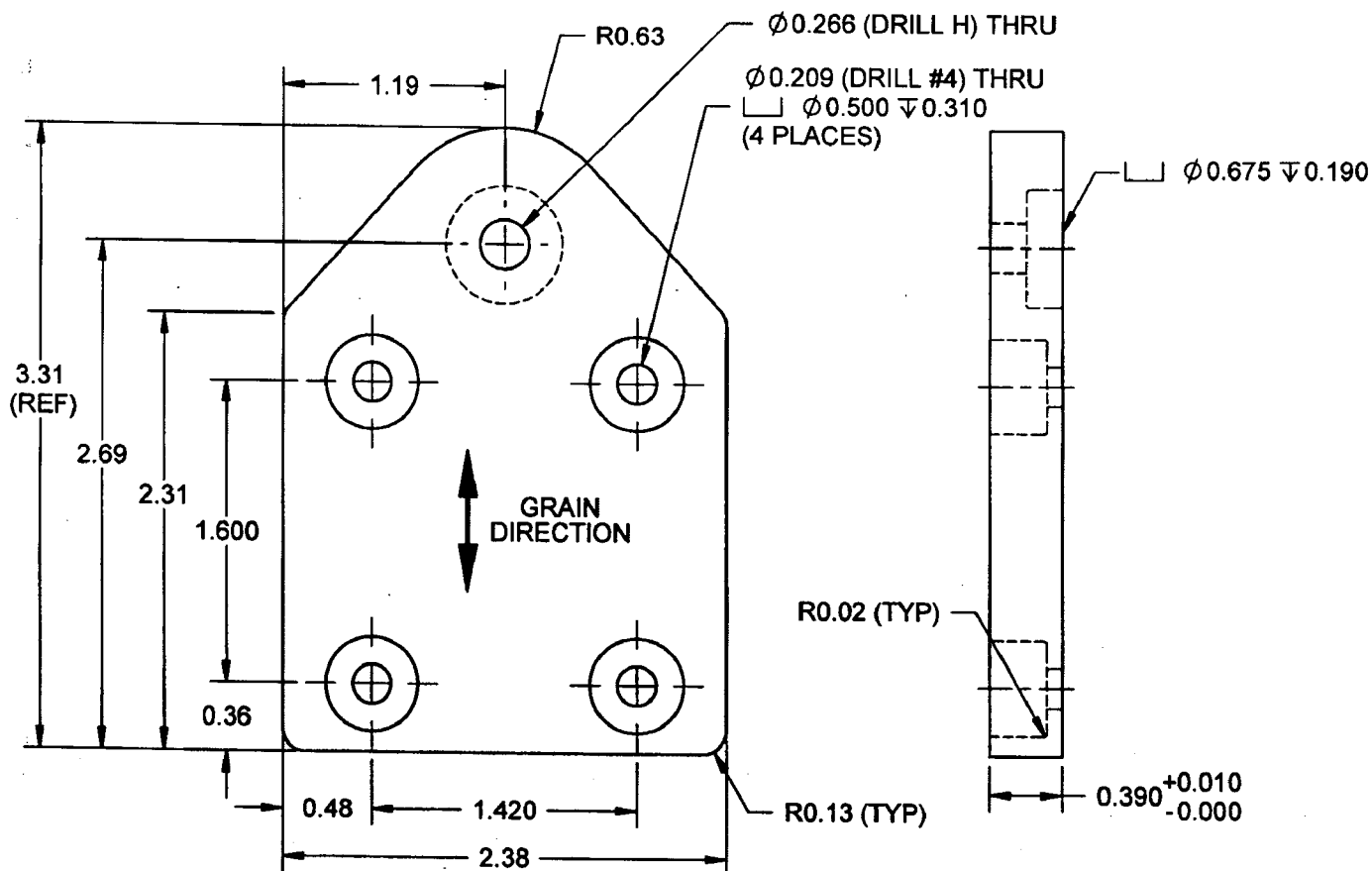
- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR
PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116 OR AMS 4160
(REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "GREY SANDEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3573-1" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX



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07-04-02



D3573-3 ADAPTER

NOTES:

- NOTES:**
- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR
PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116 OR AMS 4160
(REF DART SPEC M6061T6B)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
 - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) IDENTIFY WITH DART P/N "D3573-3" USING FINE POINT PERMANENT INK MARKER
 - 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
 - 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

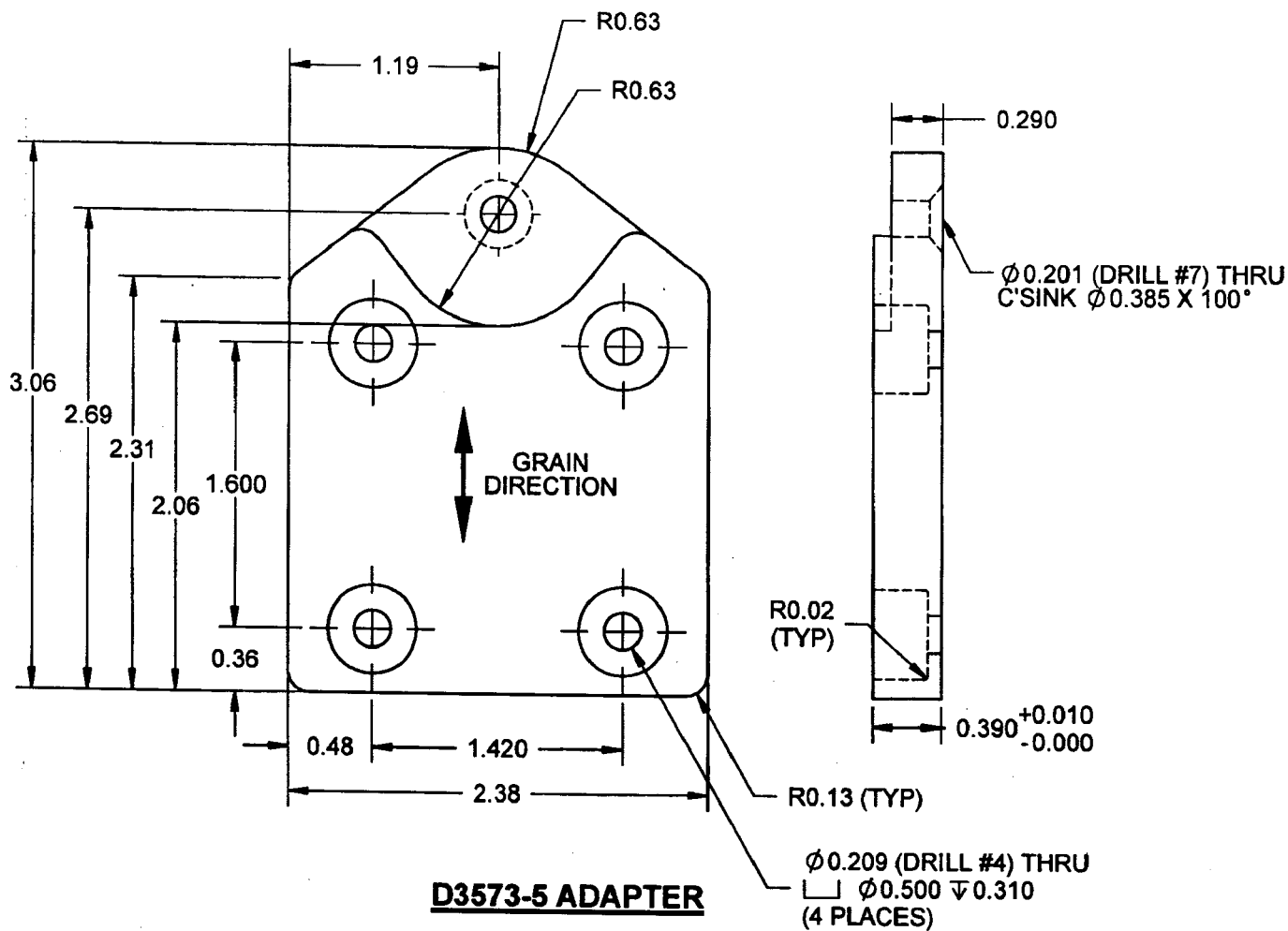
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DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3573
DATE 07.02.19	TITLE ADAPTER	REV. A SHEET 3 OF 4 SCALE 1:1

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07.04.02



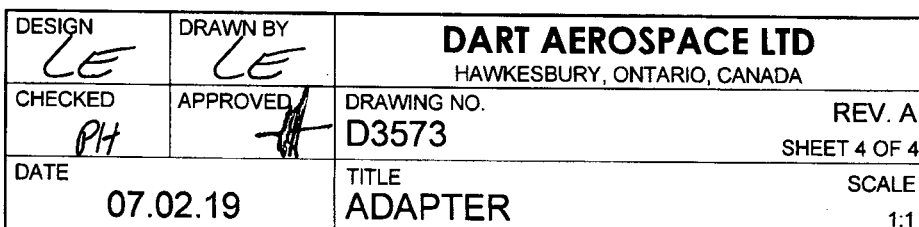
D3573-5 ADAPTER

NOTES:

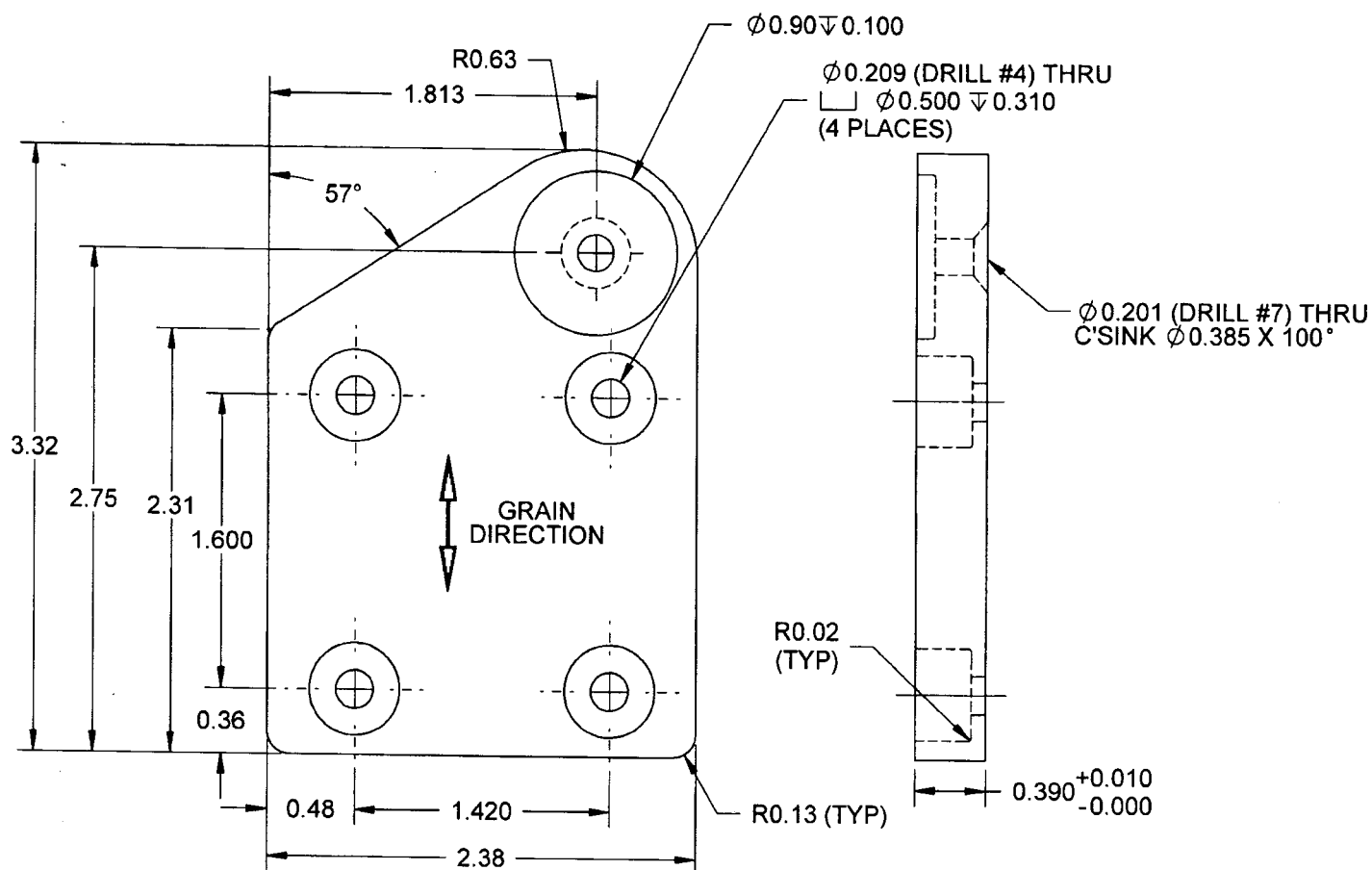
- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR
PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116 OR AMS 4160
(REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3573-5" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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07.04.02



D3573-7 ADAPTER (SHOWN)
D3573-8 ADAPTER (OPPOSITE)



NOTES:

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR
PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116 OR AMS 4160
(REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "GREY SANDEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3573-7/-8" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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